

Work Order ID 92105

92105

Page 1

October-23-12 10:37:34 AM

Item ID: D3948-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate, Anchor

Start Date: 23/10/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 06/11/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12-10-23 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3948

B

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3948-3

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

9 0 Jm 12-10-23

9 0 Jm 12-10-23

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Required Date: 06/11/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|-----------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 130 | | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | COUNTERSINK AS PER DWG | | | | | | | | |
| 140 | | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| Brake NC | Memo | 0.00 | | | | | | | |
| Brake NC | Bend as per Dwg | | | | | | | | |

DAS
15
8-83
12/10/29

9

9

12/10/31
SB 12/11/19

9

12/11/19

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Start Date: 23/10/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 06/11/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

15

9

150

0.00

12/12/19

QC

Memo

Quality Control

180

Pick Kit

0.00

180

0.00

9x

Packaging

Memo

Packaging

190

0.00

190

0.00

9x

Small Fab

Memo

Small Fab

INSTALL NUT PLATES AS PER DWG

12/11/20

12/11/20

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Item ID: D3948-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Plate, Anchor

Stop

NS2

Start Date: 23/10/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 06/11/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00

DAS

200

15

0.00

8-89

QC

Memo

12-11-20

109

Quality Control

210

Identify as per dwg & Stock Location: *076*

0.00

210

0.00

Packaging

Memo

Packaging

12/11/21

220

QC21- Final Inspection - Work Order Release

0.00

220

0.00

QC

Memo

12/11/22

Quality Control

MF
12-11-21

Picklist Print

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Page 1

Work Order ID: 92105

92105

Parent Item: D3948-043

D3948-043

Parent Item Name: Plate, Anchor

Start Date: 23/10/2012

Required Date: 06/11/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S16GA

Purchased

No

100

sf

438.7780

0.0218

0.229474

M304S16GA

**

0.3

304/316 Sheet .063

JM 12-10-28

Location

Loc Qty

Loc Code

MAT020

438.778

122245

51.078

122753

90.7

123136

297

122753

MS21059L3

Purchased

No

180

Each

242.0000

1

10

MS21059L3

**

Nut Plate

12/11/20

Location

Loc Qty

Loc Code

302

10

121185

10

314

18

122452

18

ST301

28

118614

8

119546

20

ST302

124

120308

13

120833

1

121444

100

121524

10

ST316

62

122814

62

9

Picklist Print

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Work Order ID: 92105

92105

Parent Item: D3948-043

D3948-043

Parent Item Name: Plate, Anchor

Start Date: 23/10/2012

Required Date: 06/11/2012

Start Qty: 10.00

Required Qty: 10.00

MS20426AD3-3

Purchased

No

180

Each

19,670.75

2

20

MS20426AD3-3

Rivet

**

EB 10/11/20

Location

Loc Qty

Loc Code

ST316

1470

119109

282

121011

771

19099

417

ST333

6250

123352

6250

ST334

11950.75

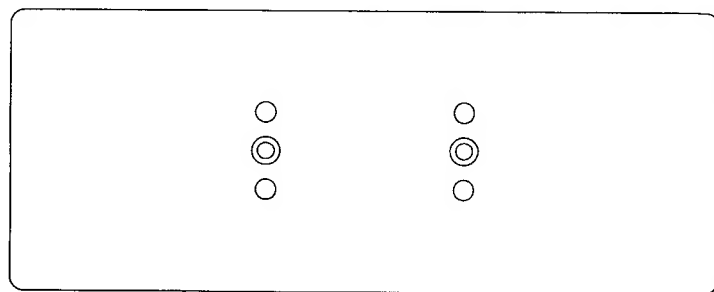
122814

11950.75

20 18

PARTS LIST

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|--------------|-------------------------|
| 1 | X | D3948-041 | PLATE, ANCHOR |
| 2 | 1 | D3948-1 | PLATE |
| 3 | 2 | MS21059L3 | NUTPLATE (OR MS21059-3) |
| 4 | 4 | MS20426AD3-3 | RIVET |

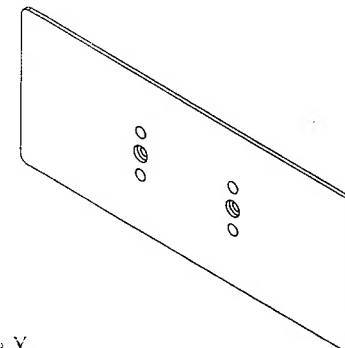


D3948-1

D3948-041 PLATE, ANCHOR

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs



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 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO A REVISION
 WITHOUT NOTICE
 WORK ORDER

92 LOS. MLS

12-10-23

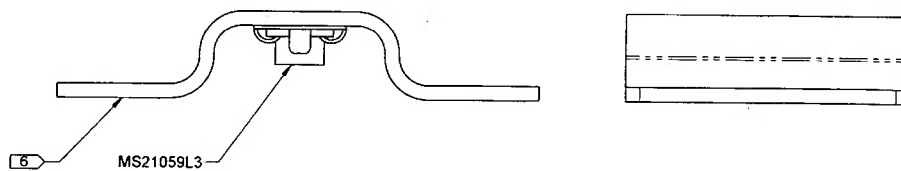
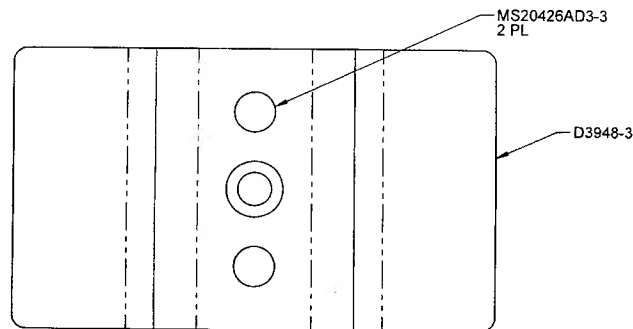
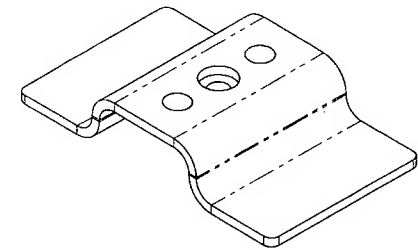
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 09/06/08

| | | | | |
|------------|--|---|--|--------------|
| B | -3F NOW MADE FROM 304 SS (ZN AB-5), 0.063 THICK WAS 0.040 (ZN AB-3, AB-5), -043/-3/-3F WIDER (ZN BG-4, BG-5) | | CP | 09.06.08 |
| A | NEW ISSUE | | CP | 09.05.13 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | | | | |
| CHECKED | | | DRAWING NO. | REV. B |
| MFG. APPR. | | | D3948 | SHEET 1 OF 5 |
| APPROVED | | | TITLE | SCALE |
| DE APPR. | | | PLATE, ANCHOR | NTS |
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92105

PARTS LIST

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|--------------|-------------------------|
| 1 | X | D3948-043 | PLATE, ANCHOR |
| 2 | 1 | D3948-3 | PLATE |
| 3 | 1 | MS21059L3 | NUTPLATE (OR MS21059-3) |
| 4 | 2 | MS20426AD3-3 | RIVET |



D3948-043 PLATE, ANCHOR

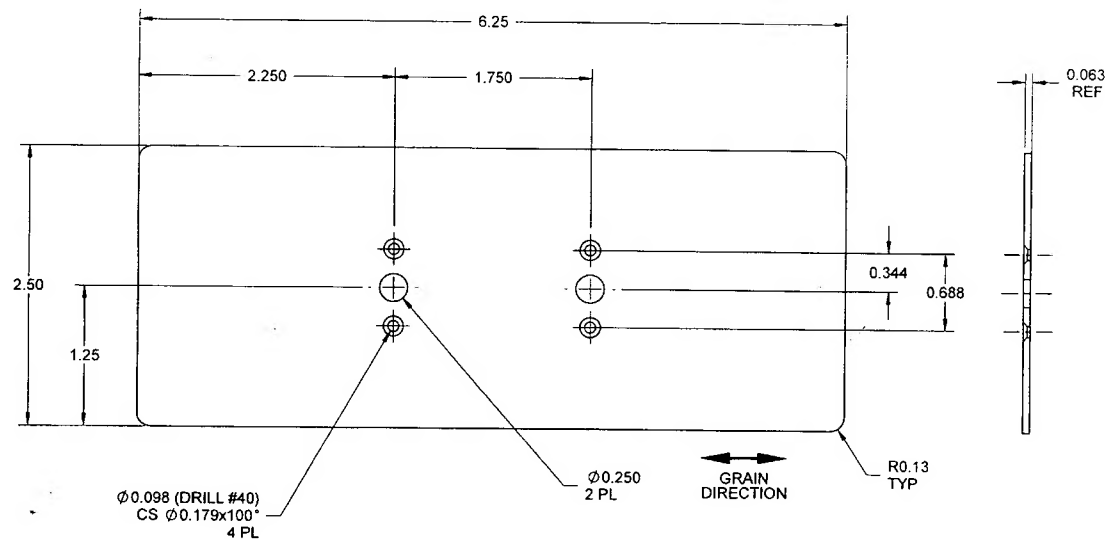
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09/06/08

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

| | | | |
|---|----------|--|--------------|
| DESIGN | 921 | DART AEROSPACE LTD | |
| DRAWN | 921 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 921 | DRAWING NO. | REV. B |
| MFG. APPR. | 921 | D3948 | SHEET 2 OF 5 |
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D3948-1 PLATE

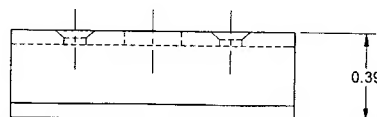
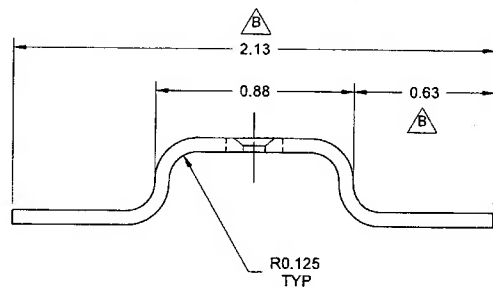
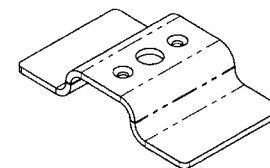
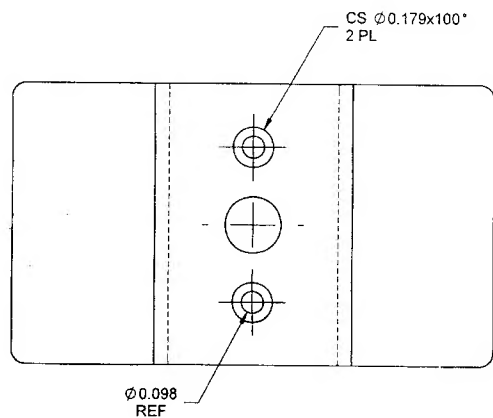
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09/06/08

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063" THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC. M6061T6S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.10 lbs

| | | |
|------------|----------|-----------------------------|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. D3948 |
| MFG. APPR. | | REV. B |
| APPROVED | | TITLE PLATE, ANCHOR |
| DE APPR. | | SCALE |
| DATE | 09.06.08 | NTS |

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D3948-3 PLATE

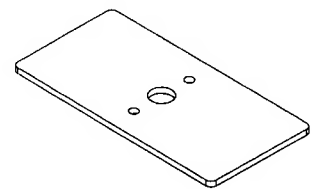
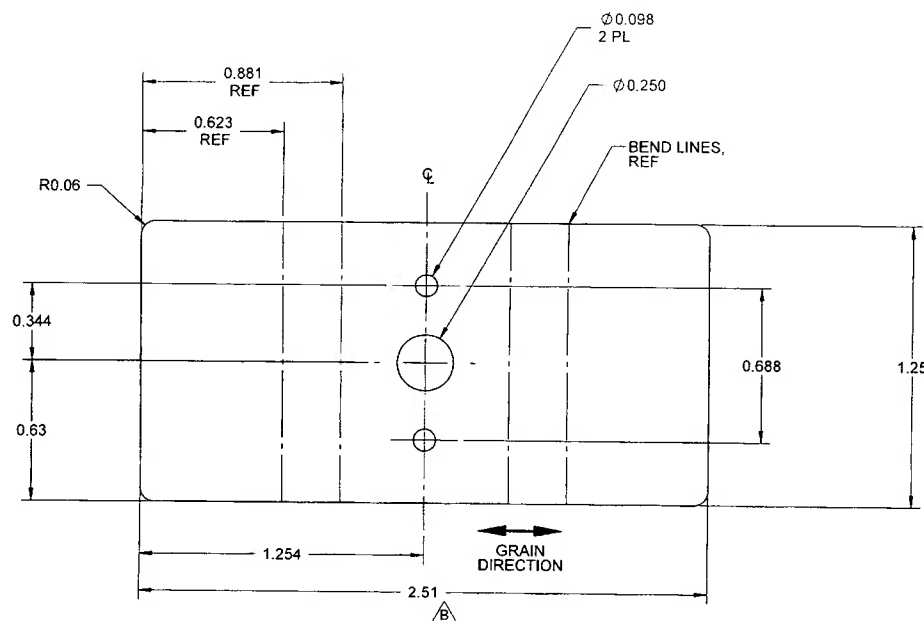
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9/26/16

NOTES:

- 1) MATERIAL: MAKE FROM D3948-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | 921 | DART AEROSPACE LTD | |
| DRAWN | 921 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 921 | DRAWING NO. | REV. B |
| MFG. APPR. | 921 | D3948 | SHEET 4 OF 5 |
| APPROVED | 921 | TITLE | SCALE |
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92105



D3948-3F PLATE

RELEASED
09/06/08

- NOTES:**
- 1) MATERIAL: AISI 304 SS SHEET 0.063" THICK (REF DART SPEC. M304S.063)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.06 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | 92 | DART AEROSPACE LTD | |
| DRAWN | 92 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 92 | DRAWING NO. | REV. B |
| MFG. APPR. | 92 | D3948 | SHEET 5 OF 5 |
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